



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18520-11A
Job Sheet 186726



Part No: RBT18520-11A

Job Qty: 2 ea

Part Name: Weight Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18520-11A REV:X IPP REV A 18.02.06 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/7/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	2 pcs		12/7/18	0.08	0.17	Small Fab-9		MLL DAS
110	QC	2 pcs		12/7/18	0.00	0.00	QC5		30
120	QC	2 pcs		12/7/18	0.00	0.00			9-89
130	Packaging	2 pcs		12/7/18	0.00	0.00	Packaging3-2		MLL
140	QC21-SA	2 Ea		12/7/18	0.00	0.00	QC21		DEC 28 2018 DAS 70

Part Op 100 - Assemble
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91375A673	Socket Head Set Screw 7/16-14 X 1.5	2 Ea (1 ea)	100-Small Fab	5131320
RBT18520-11	Weight	2 Ea (1 ea)	100-Small Fab	5134400
				5106180

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab	91375A673	2	8	0
	RBT18520-11	2	6	0

Part Specifications

Specifications could not be found.



Container No: S140578



Part: RBT18520-11A

Job No: 186726

Serial No/Batch: S140578

Revision: 11

Inspector:

Exp Date:

Instructions:

Date: 12/28/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 11/20/18 1:57 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

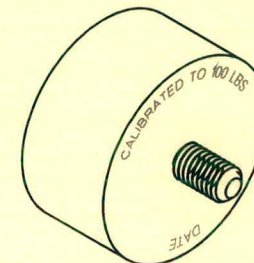
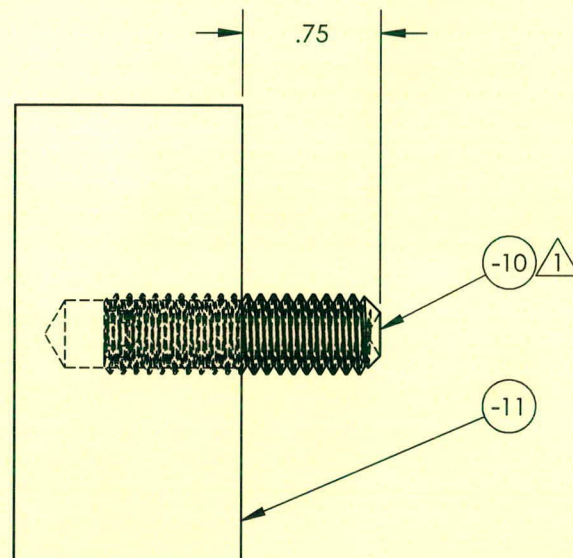
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		CH'D P/N -10 SETSCREW DEPTH TO .75 PER G.E.	9/28/2009	RJC	-
10	16-0096	-11A ADDED TO BOM.	8/5/2016	DPD	JAG
11	17-0069	-11A CH'D LOCTITE NUMBER WAS 609 IS 262.	3/22/2017	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186726 MWS
18-11-20

NOTE:

- 1 INSTALL -10 SOCKET HEAD SET SCREW USING 262 LOCTITE OR EQUIVALENT, ALLEN HEAD IN.

-11A
WEIGHT ASSEMBLY

DART AEROSPACE	
TITLE ROTOR DAMPER TEST DEVICE	
DWG NO. RBT18520-11A	REV 11
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:1	DATE 8/17/2000 SHEET 12 OF 17

